

Date: Friday, 5/25/2007 8:16:12 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HANDLE WELDMENT	
Job Number	102573		Part Number	D2530	
Estimate Number	10333		Drawing Number	D2530 REV B	
P.O. Number			Project Number	N/A	
This Issue	5/25/2007	S.O. No.	Drawing Revision	B	
Prsh Rev.	NC		Material		
First Issue	/ /	Type	Due Date	6/15/2007	Qty:
Previous Run	31787		Um:	20	Each
Written By			<i>17</i>		
Checked & Approved By	<i>SD 0705.28</i>				
Comment	Est Rev:E	Removed Purchasing	05-11-07	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 3.0602 f(s)/Unit Total : 61.2045 f(s) Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049) Batch: <i>M104627</i>	<i>FF 07-07-20</i>
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Cut to length as per Dwg D2530 2-Deburr	<i>PP 07-07-20</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<i>PP 07-07-20</i>
4.0	D2534	Lock Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: QTY Part # Description Batch 2 D2534 Lock Plate <i>19X B31145</i>	<i>15X B32620</i> <i>107/08/08</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301 2-Deburr	<i>107/08/08</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2530 PAR #: N/A Fault Category: Proc - Sm Fas NCR: Yes No DQA: AS Date: 07.08.13
 QA: N/C Closed: X Date: 07.08.21

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/08 # 20		ONE Part seen an small Bend found in end at tail End having willow R.C. Hammer error	<u>J</u> <u>BS101</u>	Scrap and destroy and replace. BN & <u>M103240</u>	<u>AS</u> 07/08/08	<u>SP</u> 07/08/08	<u>J</u> <u>BS1012</u>	<u>ES</u> 07/08/08

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:16:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 32573

Part Number: D2530

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-08-08

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-08-08

8.0 POWDER COATING POWDER COATING



M1 102316

(17x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Mr. L 07/08/13

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SP 7/8/13 S

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

E/S 07/08/13 (17)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.13

Job Completion



C207108113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

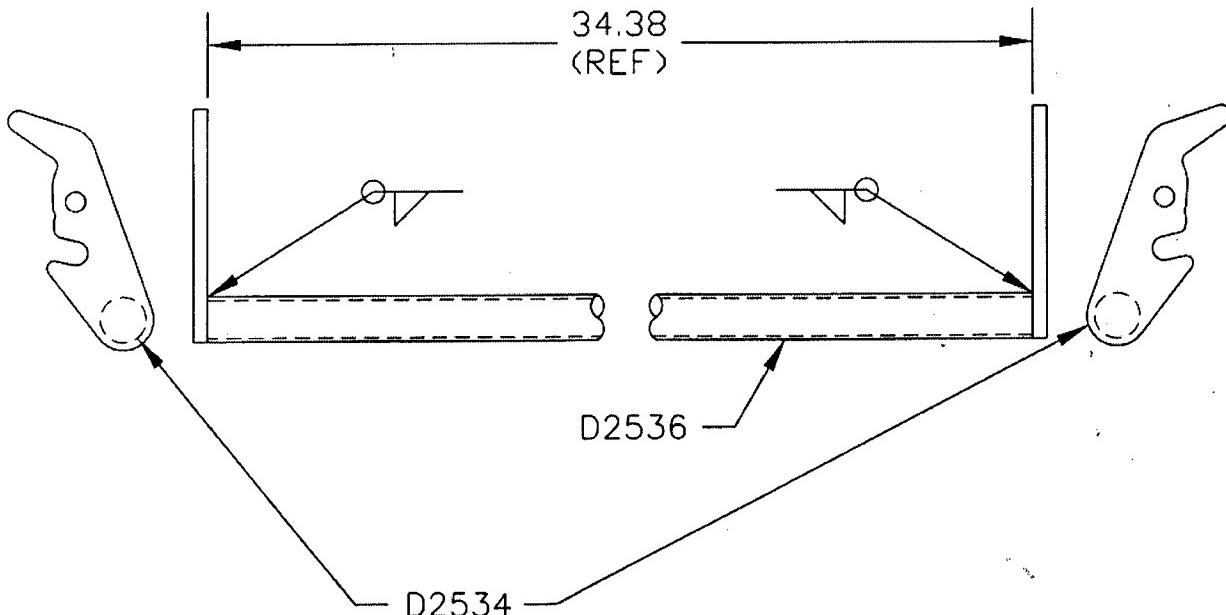
DART

DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2530
		REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT
A	96.06.18	SCALE
B	04.12.14	UPDATE NOTES AND DIMENSIONS

RELEASED

04.12.16 *[initials]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004 .
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *32573*

